

# Work Order ID 57070

Saturday, March 20, 2010 9:32:42 AM

Page 1

Item ID: D3913-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long basket Ass'y, 350

Start Date: 3/22/2010 Start Qty: 1.00

Required Date: 3/31/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Mo. 03.27

PRELIMINARY ISSUE

Approvals:

Process Plan: MF

Date: 10-3-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3913

PAT REV A Mo. 03.27

100

Weld per dwg A/R S.S. rod Batch: 4113328 0.00



Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 ✓

\*\*\*inspect before welding mesh\*\*\*

2- tack weld mesh on basket as per dwg D3913 ✓

3- weld hinge (3) and Mounting brackets as per dwg D3913 ✓

\*\*\*take lid to locate hinge and bracket\*\*\* ✓

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

SY 10/04/01

lpl 10.04.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Draw  
Number

Draw  
Rev.

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Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M113170

4:10

4:20

4:00 OF

4:50

4:40

4:00 OF

5:20

M-L 10/04/01

(IX)

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Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*EP 10/04/05 @*

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

*EP 10/04/05 @*

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Assembled to New A Part**Scaloulo**7/*

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

used on w/o 5740  
Memo

0.00

Packaging

4/10/06 @

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/06

MF

10-4-6

POSITIVE RECALL

EFFECTIVE 10/3/06 AUTH U

RELEASED J DATE 10/04/06

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Parent Item Name: Long basket Ass'y, 350


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 3/22/2010

Required Date: 3/31/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	35.0000	2.0000			

*SY* 10/03/29

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
WA	35	
46086	2	
48428	1	
50872	1	
51120	2	
51745	2	
55918	27	

✓ D3913-1 -



Rib

D3913-15



Wide Handle Plate

D3913-3 -



Rib

D3913-7 -



Rib

D3913-9 -



Rib

Manufactured No

100 Each 0.0000 1.0000

B 57078 → 1x

*SY* 10/03/29

Manufactured No

100 Each 0.0000 1.0000

B 57079 *SY* 10/03/31

Manufactured No

100 Each 0.0000 1.0000

B 57081 *SY* 10/03/29

Manufactured No

100 Each 0.0000 2.0000

B 57082 *SY* 10/03/29

Manufactured No

100 Each 0.0000 1.0000

B 57083 *SY* 10/03/29

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 3/31/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3916-041 - 		Manufactured	No			100	Each	0.0000	2.0000			
Rib Assembly								<i>10.03.19</i>				B56941 ② <i>SL 10/03/29</i>
D3916-5 - 		Manufactured	No			100	Each	0.0000	3.0000			
Light Rib												B57023 ③ <i>SL 10/03/29</i>
D4016-1 		Manufactured	No			100	Each	0.0000	3.0000			
Hinge Half, Base												B56949 ③ <i>SL 10/03/29</i>
D4017-7 - 		Manufactured	No			100	Each	0.0000	1.0000			
Rib												B57084 ① <i>SL 10/03/29</i>
D4017-9 - 		Manufactured	No			100	Each	0.0000	2.0000			
Rib												B57085 ② <i>SL 10/03/29</i>
D4020-1 		Manufactured	No			100	Each	0.0000	1.0000			
Mesh (350 Basket Long, Base)												B56988 ① <i>SL 10/03/31</i>
D4020-11 		Manufactured	No			100	Each	0.0000	2.0000			
End Mesh, Basket								<i>10.03.19</i>				B56990 ② <i>SL 10/03/31</i>

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Shop Packet Print

Page 2

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4021-1 Handle Plate		Manufactured	No			100	Each	3.0000	3.0000			

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

WA

3

56044

3

D4034-041 -

Manufactured

No

100

Each

0.0000

1.0000

Aft Upper Rib Assembly

D4034-043 -

Manufactured

No

100

Each

0.0000

1.0000

Fwd Upper Rib Assembly

AN 3-10A

Purchased

No

150

Each

56.0000

6.0000

Bolt

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST351

56

11119

56

1105940

B57086 ③ 10/03/29

B56991 ① 10/03/29

B56992 ① 10/03/29

9510/04/05

6

11119

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD8



Washer

Purchased

No

150

Each

226.0000

2.0000

A



9/5/10/04/05

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST347

226

107091

9

108335

11

110382

48

110917

3

111578

15

112385

140

D2931



Bumper

Manufactured

No

150

Each

895.0000

2.0000



9/5/10/04/05

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST504

895

46064

895

D4021-5



Blanking Plate

Manufactured

No

150

Each

0.0000

2.0000



9/5/10/04/05

57087  
2X  
57360

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MS20600-AD4W3  Cherry Rivets		Purchased	No			150	Each	2,319.000	2.0000			

*Handwritten:* 2  
*Signature:* GS 10/04/05

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST321	2319
102929	37
104715	10
106375	304
107939	1000
111636	968

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*2*  
\_\_\_\_\_  
\_\_\_\_\_

MS21042L3  
  
Nut

Purchased

No

Each

2,141.000 1.0000



*Handwritten:* GS 10/04/05

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST300	2141
110844	35
111274	27
111668	58
112314	285
112385	16
113523	20
113537	700
113644	1000

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*6*  
\_\_\_\_\_  
\_\_\_\_\_

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149F0332P

Purchased

No

150

Each

1,110.000

12.0000



WASHER

*Handwritten signature and date: 3/30/05*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST275

1110

18057

1110

*Handwritten number: 12*

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Shop Packet Print

Page 6

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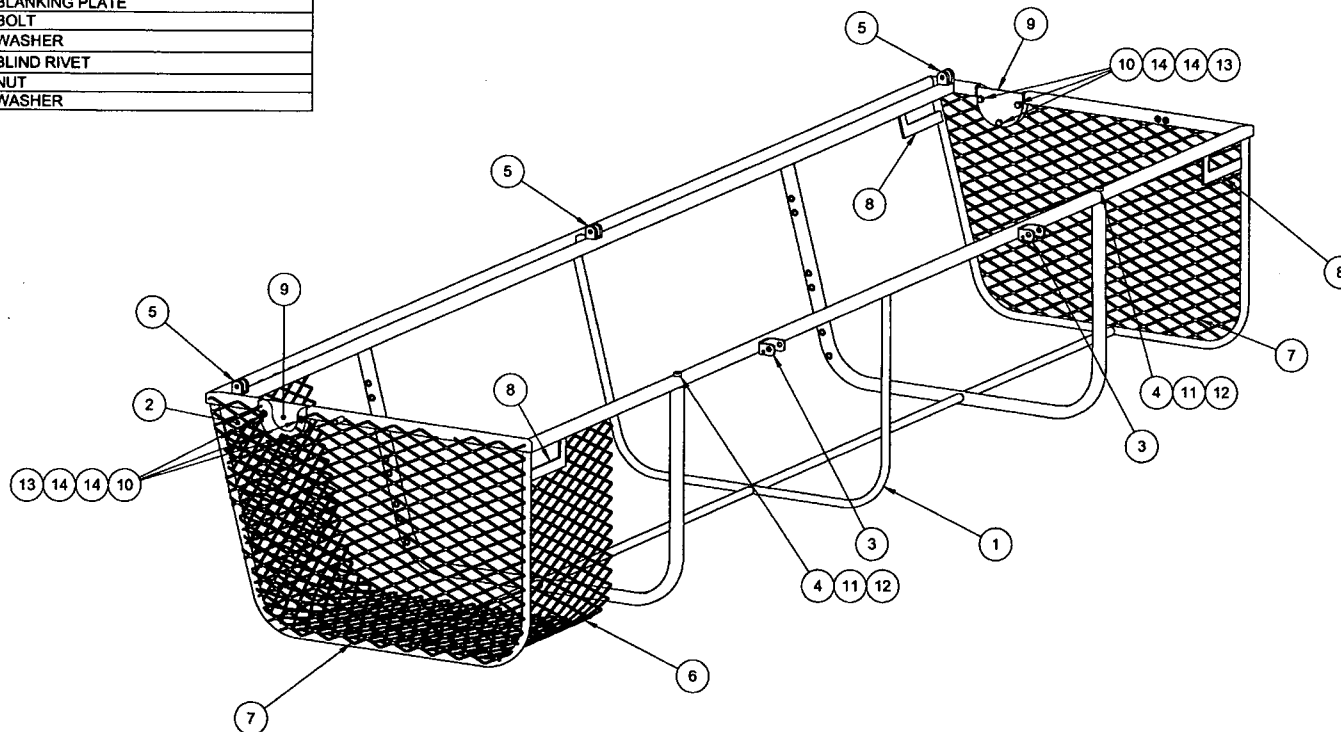
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

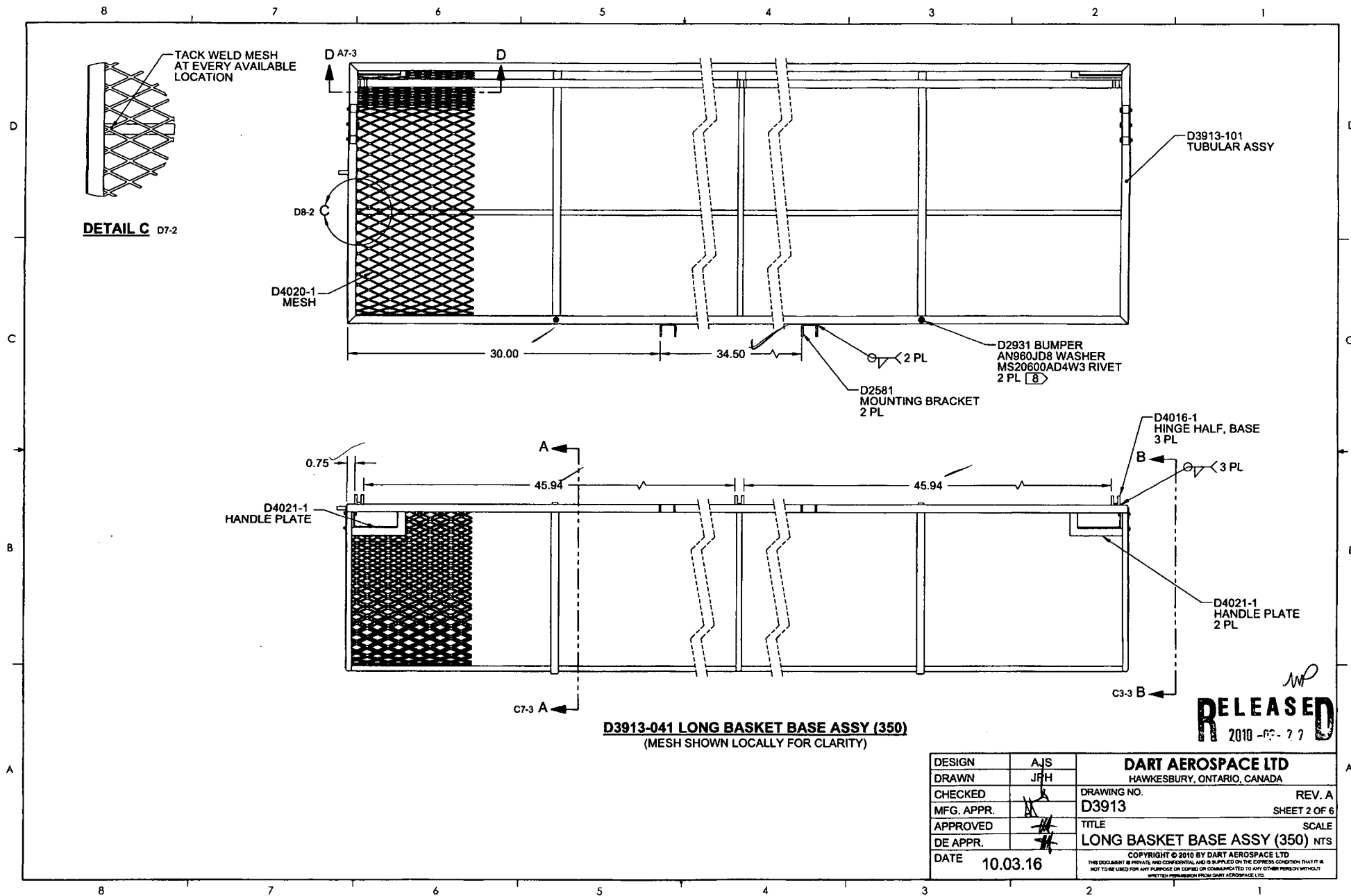
**RELEASED**  
2010-03-22  
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	<b>D3913</b>	SHEET 1 OF 6
TITLE	<b>LONG BASKET BASE ASSY (350)</b>	SCALE NTS
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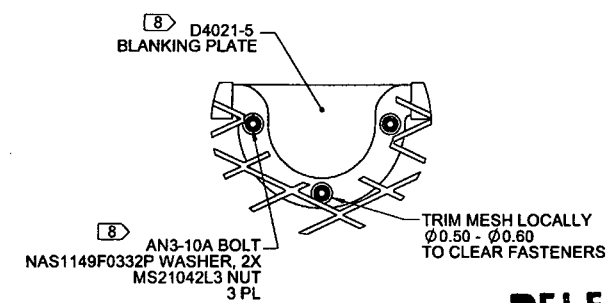
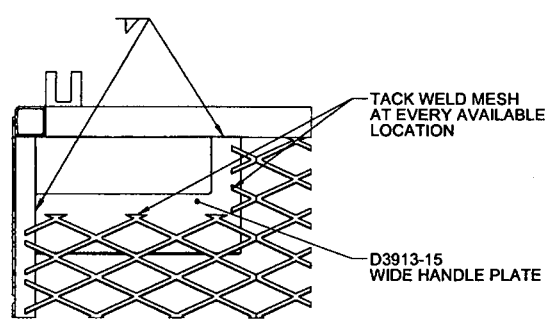
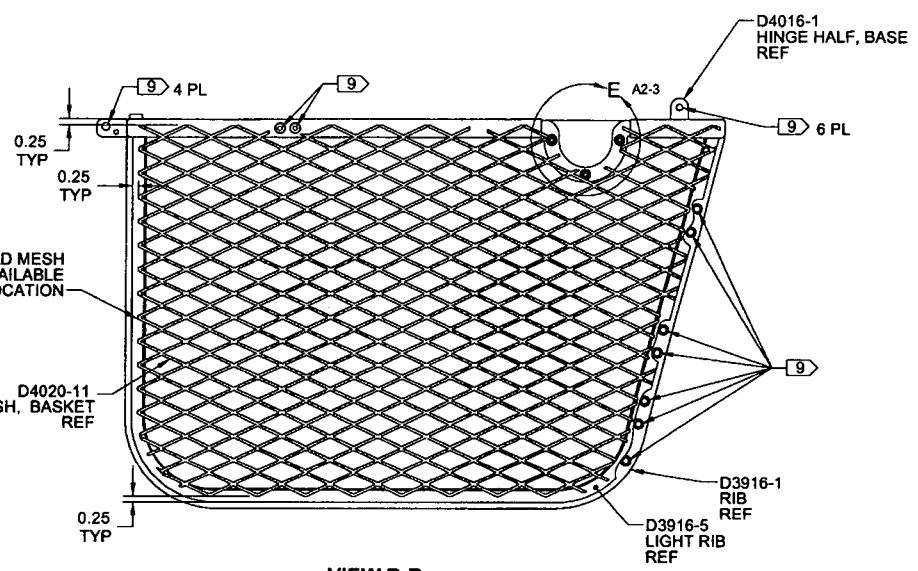
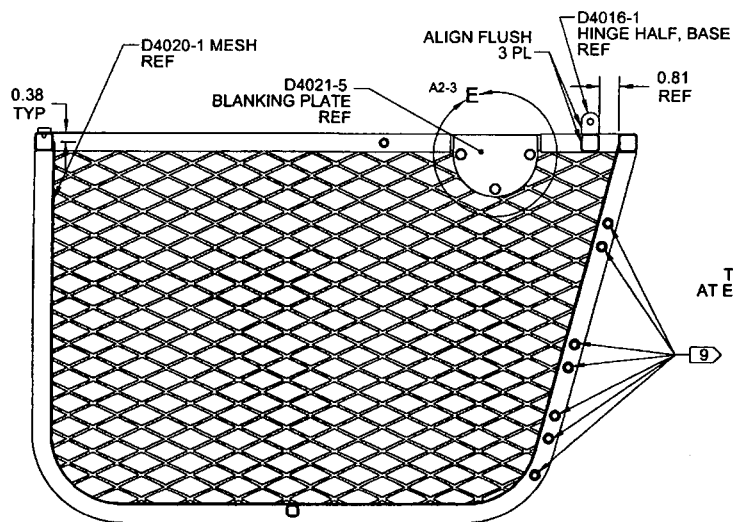
W057070







**RELEASED**  
2010-03-16

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3913</b>	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET BASE ASSY (350)</b>	NTS
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WFO 57070

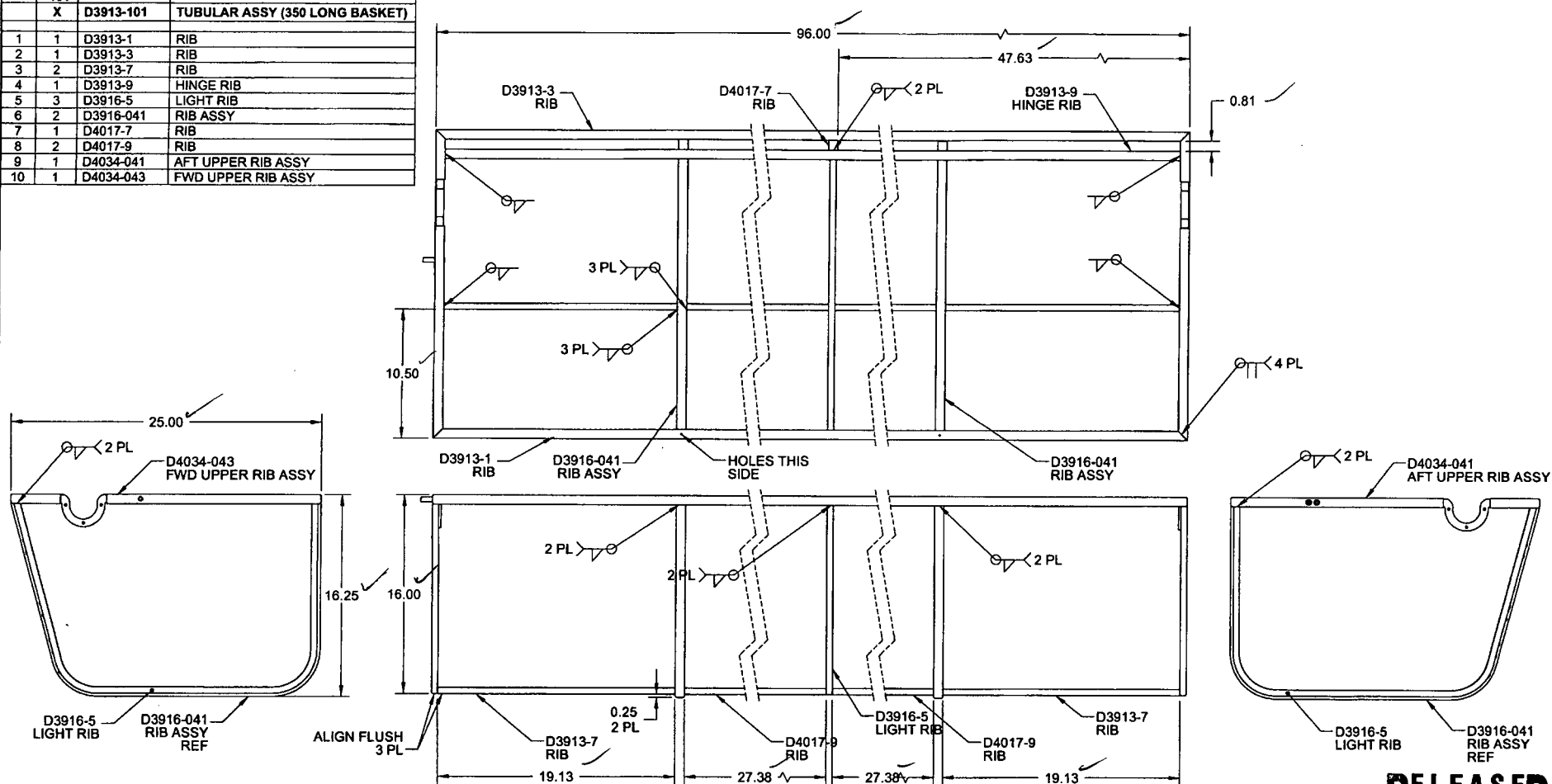


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2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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W/O 57070

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

## NOTES:

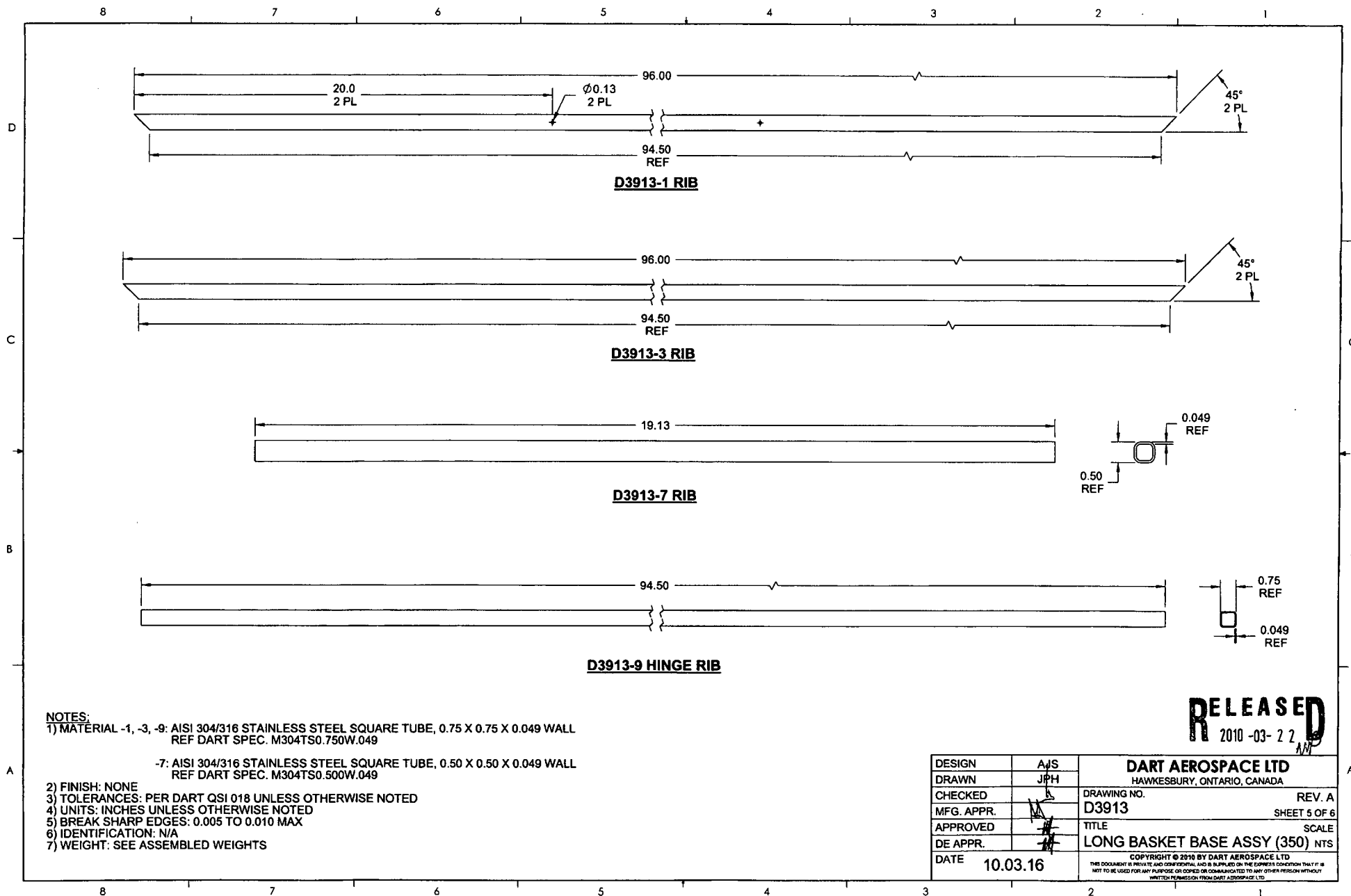
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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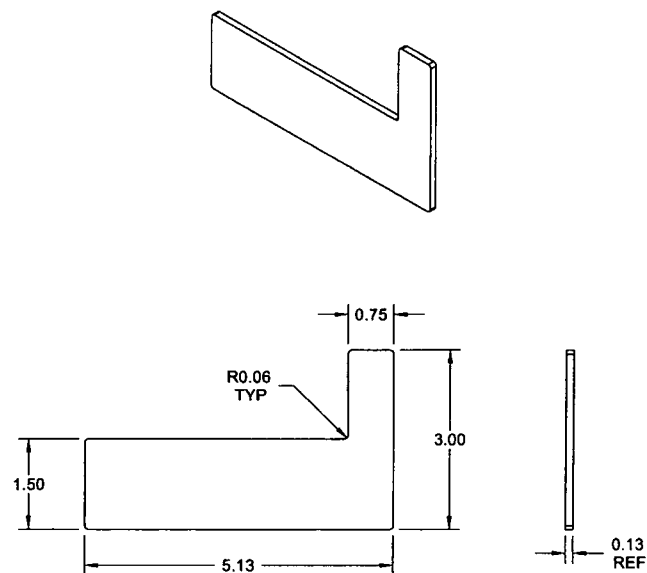
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W/0 57070



W/057070



**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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